

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017860**Date Inspected:** 13-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13 section**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

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Caltrans QA Inspector observed two welding operators in process of semi-automatic SAW on CJP weld. The CJP weld is connected between two U-rib deck panels (DP) of lift #13CW. The weld number and plate number are SA3232-003/DP3151A to DP3152A. The region of the weld joint has been pre-heating to specific desired temperature prior SAW welding. The parameters used for the CJP welding of the deck panel were conducted in accordance with Caltrans approved WPS. The SAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Caltrans QA Inspector observed two ZPMC welders performed FCAW root pass process on plate to plate of bottom plate (BP) and side plate (SP) for lift #13AW. The weld is designed CJP butt joint with back gouging welded flat position (1G). The bottom plate and weld ID are SP3099A to BP13AW. The region of the weld joint has been pre-heating to specific desired temperature prior FCAW root pass welding. The parameters used for the FCAW welding of the bottom plate were conducted in accordance with Caltrans approved WPS. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Caltrans QA Inspector observed a ZPMC welder performed fit up and SMAW tack weld process on two anchor plate (AP). The anchor plate and weld ID are AP3020 to AP3021/SEG3020A-003 of lift 14W. The weld is designed CJP butt joint with back gouging welded flat position (1G). The region of the weld joint has been pre-heating to specific desired temperature prior SMAW tack weld welding. The parameters used for the SMAW

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welding of the anchor plate were conducted in accordance with Caltrans approved WPS. The SMAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Caltrans QA Inspector observed two welders performed a FCAW fillet weld process on stiffener plates. The stiffener weld is designed a T-joint with size 6mm and 8mm fillet weld welded on stiffener to anchor plate of OBG east line lift #14E . The angle plate ID is AP3002 and AP3009, The region of the weld joint has been pre-heating to specific desired temperature prior FCAW welding. The parameters used for the FCAW welding of stiffeners were conducted in accordance with Caltrans approved WPS. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

CLOSING STATEMENT

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
